

Date: Wednesday, 5/16/2007 8:13:35 AM
 User: Kim Johnston

Process Sheet

SPHIT-1

23

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32378 - 1
 Estimate Number : 10832
 P.O. Number : N/A
 This Issue : 5/16/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 31250
 Written By : 07.05.16
 Checked & Approved By : 07.05.16
 Comment : Est B 00.06.26 New DWG rev (mpp 2069) EC
 Est Rev C As per Rev C 07-03-19 JLM

Drawing Name : 206/01-58 SADDLE, OUTBOARD, RIGHT SIDE
 Part Number : D29322
 Drawing Number : D2932 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 6/6/2007 Qty: 16 Unit: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6101003

7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0 x 6.25 X 7.88

Grain Along Long 7.88 Length

Batch No: B31387

JML 07/06/25

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr

JML 07/06/25

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

JML 07/06/25

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

JML 07/06/25

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 32378

Part Number: D29322

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 01.06.26

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-h 01/06/27 (2x)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

P/O: 4058 C/L 7/10/27 (2)

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

2070703

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 7/7/4 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20710704 (2)

Job Completion



u 07.07.04

DART AEROSPACE LTD		Work Order:	32378
Description: 206 Saddle, Outboard, Right side		Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.125	0.126	0.126	0.126		
B	0.100	0.140		0.127	0.127	0.126	0.126		
C	0.100	0.140		0.120	0.119	0.120	0.120		
D	0.210	0.230		0.225	0.222	0.223	0.223		
E	1.245	1.255		1.249	1.256	1.258	1.250		
F	1.245	1.255		1.249	1.258	1.258	1.256		
G	2.495	2.505		2.500	2.499	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.576	1.576	1.575	1.577		
J	2.495	2.505		2.499	2.500	2.499	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		0.119	0.117	0.117	0.117		
O	0.540	0.560		0.548	0.549	0.550	0.548		
P	0.490	0.510		0.499	0.504	0.502	0.504		
Q	3.715	3.725		3.717	3.717	3.716	3.717		
R	2.470	2.510		2.494	2.494	2.494	2.492		
S	0.240	0.270		0.255	0.254	0.257	0.253		
T	0.100	0.180		0.140	0.138	0.138	0.138		
U	1.625	1.635		1.628	1.629	1.629	1.628		
V	1.362	1.372		1.368	1.367	1.367	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.133	1.134	1.134		
Y	1.565	1.585		1.574	1.573	1.573	1.573		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JMK	Audited by:	SA
Date:	07/06/25	Date:	01.06.26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD		Work Order: 323783
Description: 206 Saddle, Outboard, Right side		Part Number: D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140							
B	0.100	0.140							
C	0.100	0.140							
D	0.210	0.230							
E	1.245	1.255							
F	1.245	1.255							
G	2.495	2.505							
H	0.510	0.515							
I	1.572	1.582							
J	2.495	2.505							
K	0.257	0.262							
L	0.312	0.317							
M	0.235	0.240							
N	0.100	0.140							
O	0.540	0.560							
P	0.490	0.510							
Q	3.715	3.725							
R	2.470	2.510							
S	0.240	0.270							
T	0.100	0.180							
U	1.625	1.635							
V	1.362	1.372							
W	0.316	0.321							
X	1.125	1.145							
Y	1.565	1.585							
Z	0.178	0.198							
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD		Work Order: 32378
Description: 206 Saddle, Outboard, Right side		Part Number: D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

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F	1.245	1.255							
G	2.495	2.505							
H	0.510	0.515							
I	1.572	1.582							
J	2.495	2.505							
K	0.257	0.262							
L	0.312	0.317							
M	0.235	0.240							
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W	0.316	0.321							
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Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
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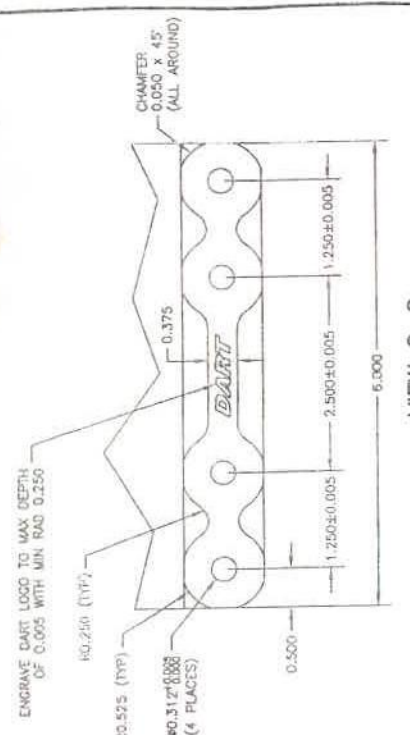
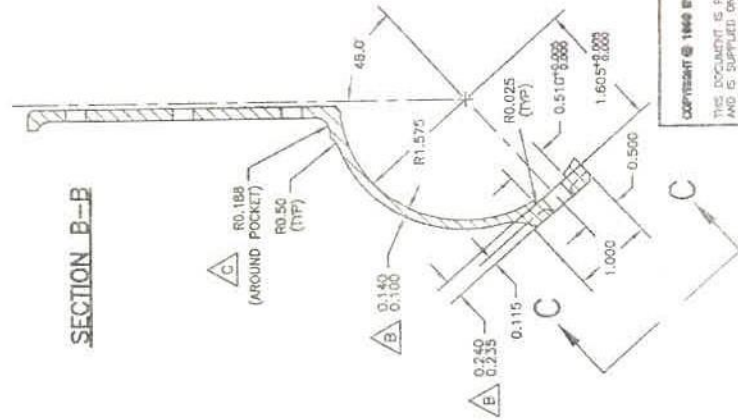
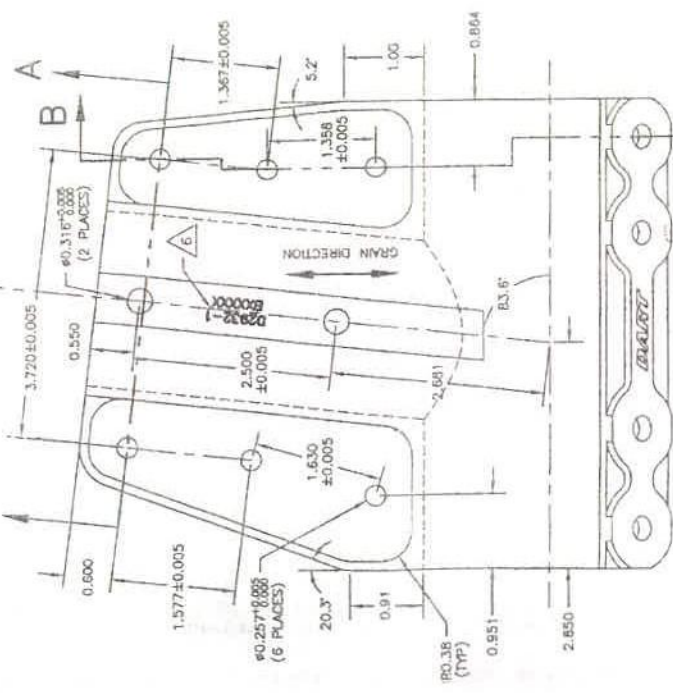
DART AEROSPACE LTD		Work Order: 32373
Description: 206 Saddle, Outboard, Right side		Part Number: D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140							
B	0.100	0.140							
C	0.100	0.140							
D	0.210	0.230							
E	1.245	1.255							
F	1.245	1.255							
G	2.495	2.505							
H	0.510	0.515							
I	1.572	1.582							
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U	1.625	1.635							
V	1.362	1.372							
W	0.316	0.321							
X	1.125	1.145							
Y	1.565	1.585							
Z	0.178	0.198							
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:		Audited by:	
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (30-A-250/12)
 - 2) FINISH: (MAKE FROM D6101-003 SADDLE BULLET, 7075) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE

DESIGN: **CB**
 DRAWING NO: **D2932**
 DATE: **06.11.09**
 TITLE: **SADDLE OUTSIDE**
 SHEET 1 OF 1
 SCALE: **2:1**

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